

Date: Tuesday, 9/4/2007 11:30:19 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HEAT OUTLET DEFLECTOR
Job Number : 34417	
Estimate Number : 12156	
P.O. Number : <i>NIA</i>	Part Number : D34725
This Issue : 9/4/2007 S.O. No. : <i>NIA</i>	Drawing Number : D3472 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 34416	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 10/4/2007 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : est rev. A 06.02.02 new issue EC	
est rev. B 06.03.29 added alodine EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.1428 sf(s)/Unit Total : 6.8569 sf(s)
 2024-T3 .063 sheet
 Batch: *M101022*

SAD 07/09/10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 Cut as per Dwg D3471
 Dwg Rev: *A*
 Prog Rev: *A*

SAD 07/09/10

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/10

(6)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/09/10

counted

(6)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Deburr
 2- Buff out scratches

B 07/09/10 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/09/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAT OUTLET DEFLECTOR

Job Number: 34417

Part Number: D34725

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 04-09-18 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 01/02/18 (6) counter

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

E 07/09/18 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(6) 07/09/19

Job Completion



W 07-09-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

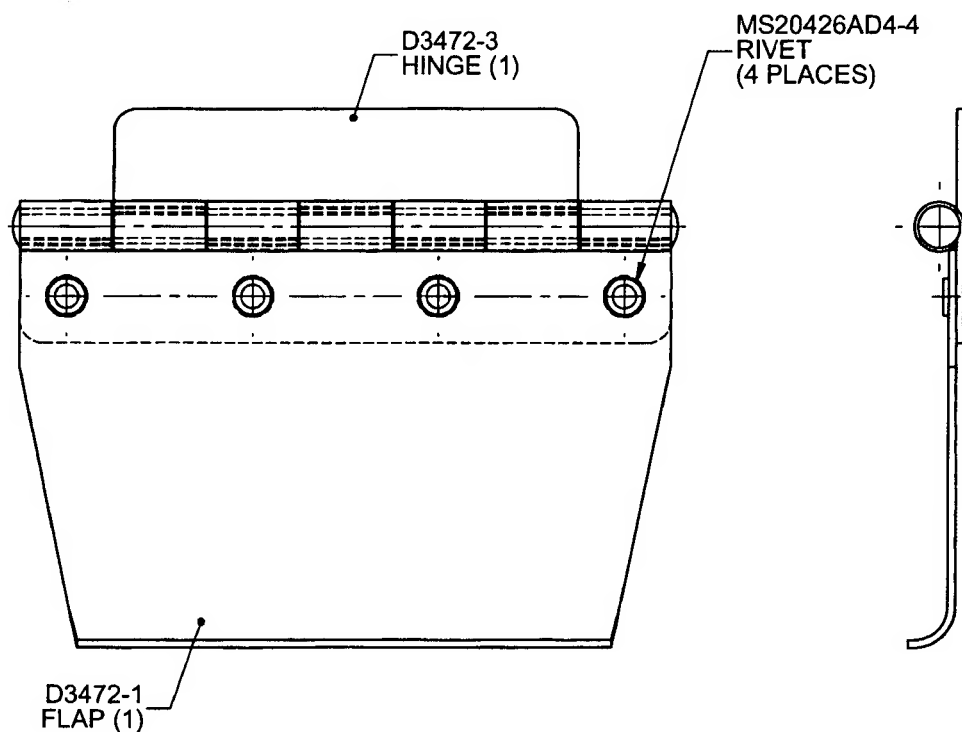
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3472	REV. A SHEET 1 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1
A	06.01.17	NEW ISSUE	

06.04.03 H

**D3472-041 CABIN HEAT OUTLET DEFLECTOR**

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WITHOUT NOTICE
WORK ORDER
NO. 34417

NOTES:

- 1) IDENTIFY WITH DART P/N D3472-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

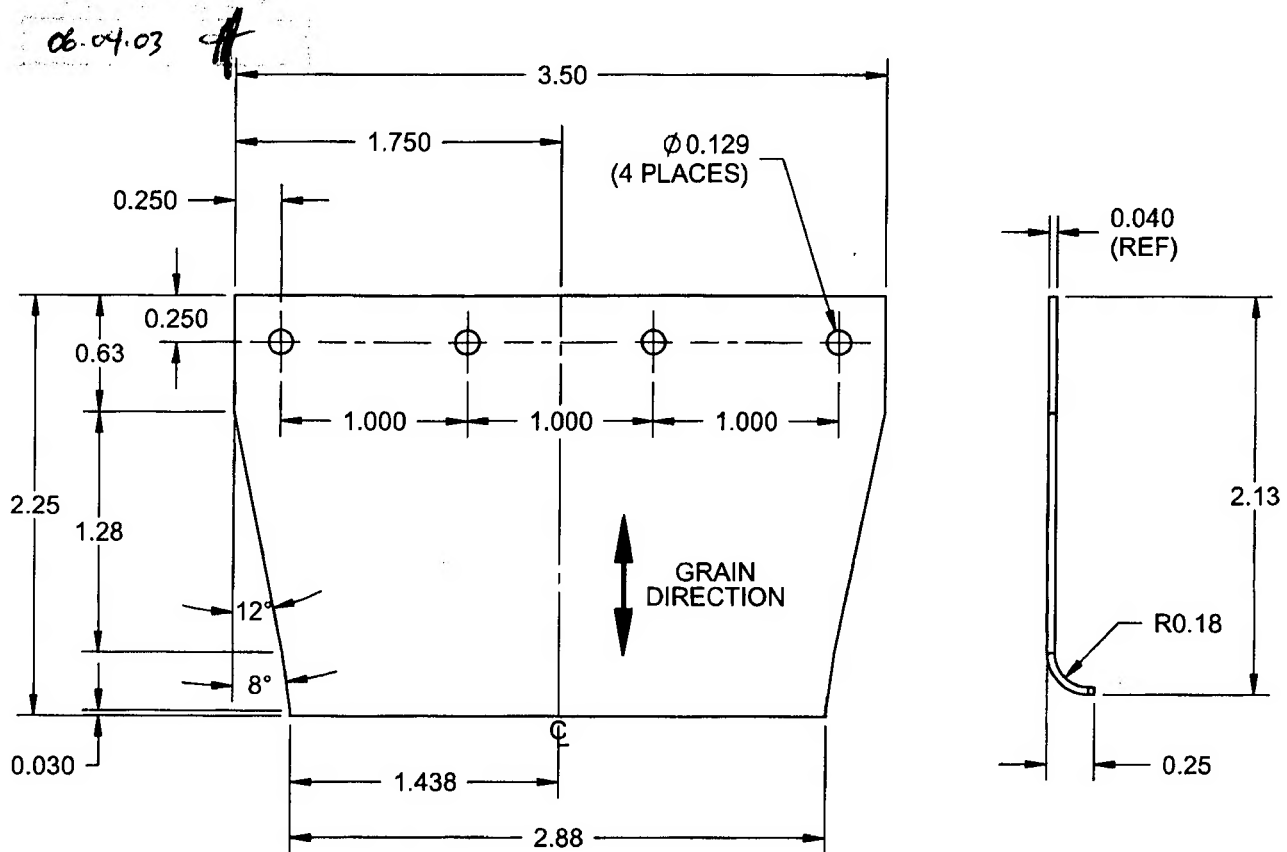
QTY -041	P/N	DESCRIPTION
X	D3472-041	CABIN HEAT OUTLET DEFLECTOR
1	D3472-1	FLAP
1	D3472-3	HINGE
4	MS20426AD4-4	RIVET

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3472	REV. A SHEET 2 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1

**D3472-1F FLAP FLAT PATTERN****D3472-1 FLAP
BENDING DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 34417

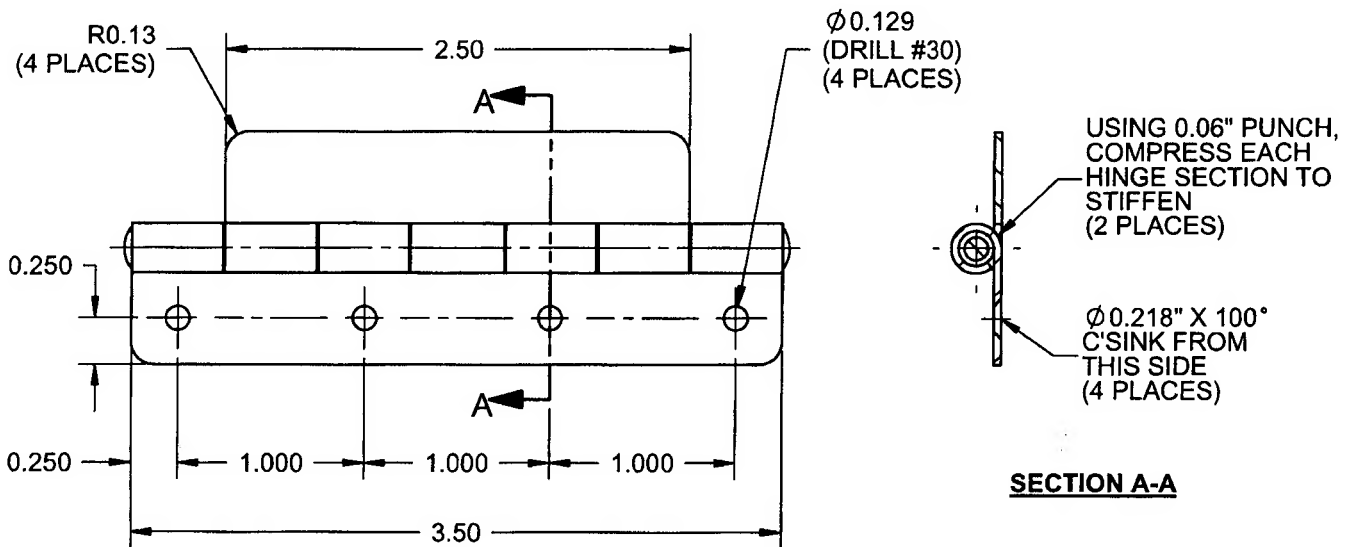
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CHECKED #	APPROVED #	DRAWING NO. D3472	REV. A SHEET 3 OF 4
DATE 06.01.17	TITLE HEAT OUTLET DEFLECTOR		SCALE 1:1

06.04.07 #

**D3472-3 HINGE****NOTES:**

- 1) MAKE FROM MS20257-3 HINGE, MODIFIED AS SHOWN
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. **34417**

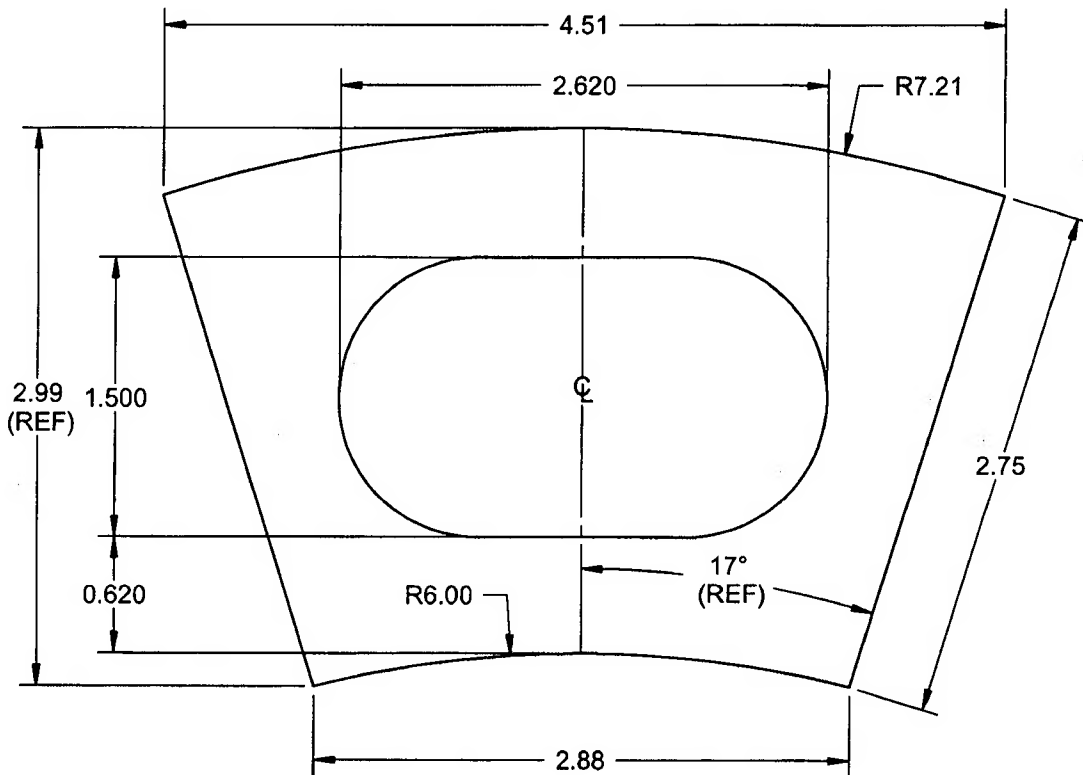
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DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3472	REV. A SHEET 4 OF 4
DATE 06.01.17	TITLE HEAT OUTLET DEFLECTOR		SCALE 1:1

06.01.03 [Signature]

**D3472-5 FLAT DOUBLER****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) IDENTIFY WITH DART P/N D3472-5 USING
FINE POINT PERMANENT INK MARKER
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 34417

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DART AEROSPACE LTD	Work Order:	34917
Description: Heat outlet Deflector	Part Number:	D34725
Inspection Dwg: D3472 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	SAD	Audited by:	[Signature]	Prototype Approval:	[Signature]
Date:	07/09/10	Date:	07/09/10	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	